

Work Order ID 76787

76787

Page 1

November-21-11 11:11:51 AM

Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly Aft, Low Gear
 Start Date: 21/11/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 04/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/21 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3805 | B |

100 0.00
100
 Large Fab
 Large Fab
 Memo
 1-weld D3806-5 to D3805-5 together as per dwg D3805
 304 S.S. Welding Rod
 BATCH #: M118367
 2-Transfer drill holes in bar 2059B → 120165
 110 0.00
110
 QC
 Quality Control
 QC9- Inspect visual per QSI004- Fusion Welds
 Memo
 10x Ø
 (10) 212/12 12/02/01
CP12.02.01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

130 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

130

Powdercoat

Powder Coating

Memo

START TIME: 1-50

OVEN TEMPERATURE: 320 °F

FINISH TIME: 2-20

0.00

140 QC3- Inspect Part Finish 0.00

140

QC

Memo

0.00

Quality Control

10X4 M-L 12/02/02

10 BL 12-2-2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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 Required Date: 04/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|--------------------------------------|
| 150 | | 0.00 | | | | | | | |
| *150* | | | | | | (10) | 0 | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH <u>120159</u> | | | | | | | | Ac 12/02/07 |
| 160 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | (416) |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location: <u>FP-1</u> | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | x10 0 12/02/07 counted x measured |

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NOTE: Date & initial all entries

Work Order ID 76787***76787***

Page 4

November-21-11 11:11:51 AM

Item ID: D3805-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 21/11/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 04/01/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/2/11
(10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

November-21-11 11:11:55 AM

Page 1

Work Order ID: 76787

76787

Parent Item: D3805-045

D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 21/11/2011

Required Date: 04/01/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|----------------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3805-5 | | Manufactured | No | | | 100 | Each | 52.0000 | 1 | 8 | | | |
| *D3805-5* | | | | | | | | | | | | | |
| Plate | | | | | | | | | | | | | |
| | | 78811 X3 | | | | | | | | | | | |
| | | B78128 X3 | | | | | | | | | | | |
| | | 78128 X3 | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA | | 52 | | | | | | | |
| | | | | | 75676 | 46 | | | | | | | |
| | | | | | 75939 | 6 | | | | | | | |
| D3806-5 | | Manufactured | No | | | 100 | Each | 2.0000 | 1 | 8 | | | |
| *D3806-5* | | | | | | | | | | | | | |
| Bar | | | | | | | | | | | | | |
| | | B78811 X3 | | | | | | | | | | | |
| | | B74889 X10 | | | | | | | | | | | |
| | | B78128 X7 | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA030 | | 2 | | | | | | | |
| | | | | | 46781 | 2 | | | | | | | |
| D3807-5 | | Manufactured | No | | | 150 | Each | 6.0000 | 1 | 8 | | | |
| *D3807-5* | | | | | | | | | | | | | |
| Gasket | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | GA | | 6 | | | | | | | |
| | | | | | 74944 | 6 | | | | | | | |

(10) MR/EZ 12/02/01

(10) MR/EZ 12/02/01

Ae 12/02/06

B76742 (x1)
B78132 (x9)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

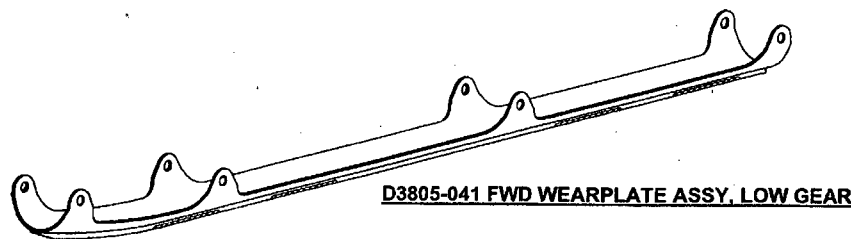
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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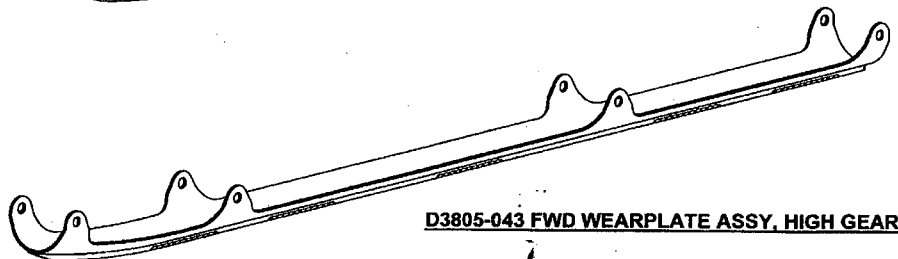
NOTE: Date & initial all entries

8 7 6 5 4

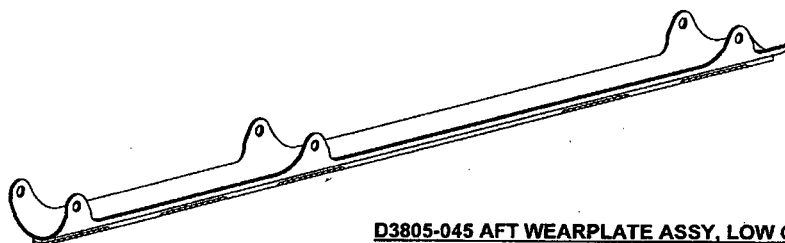
3 2 1



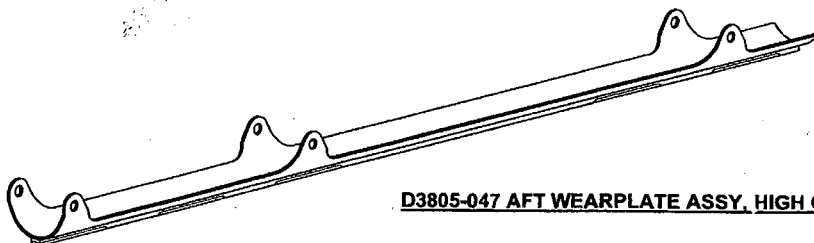
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|--------------------|-------------------------------|
| 1 | X | | | | D3805-041 | FWD WEARPLATE ASSY, LOW GEAR |
| 2 | | X | | | D3805-043 | FWD WEARPLATE ASSY, HIGH GEAR |
| 3 | | | X | | D3805-045 | AFT WEARPLATE ASSY, LOW GEAR |
| 4 | | | | X | D3805-047 | AFT WEARPLATE ASSY, HIGH GEAR |
| 11 | 1 | | | | D3805-1 | PLATE |
| 12 | | 1 | | | D3805-3 | PLATE |
| 13 | | | 1 | | D3805-5 | PLATE |
| 14 | | | | 1 | D3805-7 | PLATE |
| 15 | 1 | | | | D3806-1 | BAR |
| 16 | | 1 | | | D3806-3 | BAR |
| 17 | | | 1 | | D3806-5 | BAR |
| 18 | | | | 1 | D3806-7 | BAR |
| 19 | 1 | | | | D3807-1 | GASKET |
| 20 | | 1 | | | D3807-3 | GASKET |
| 21 | | | 1 | | D3807-5 | GASKET |
| 22 | | | | 1 | D3807-7 | GASKET |
| 31 | A/R | A/R | A/R | A/R | 2059B | HARDCOAT |
| 32 | A/R | A/R | A/R | A/R | 1300 (OR 1300L) | 3M SCOTCH-GRIP ADHESIVE |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76787 M.C.5
11/11/21

RELEASED
2011-10-03

| | | | | |
|---|---|---|--------------|----------|
| B | REVISED D3805-1F1-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3 | | MB | 11.09.16 |
| A | NEW ISSUE | | MB | 08.11.21 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN |  | DART AEROSPACE USA, INC. KENT, WA | | |
| DRAWN |  | | | |
| CHECKED |  | | | |
| MFG. APPR. |  | | | |
| APPROVED |  | | | |
| DE APPR. |  | | | |
| DATE | 11.09.16 | | | |
| | | DRAWING NO. | REV. B | |
| | | D3805 | SHEET 1 OF 8 | |
| | | TITLE | SCALE | |
| | | WEARPLATE ASSY | NTS | |
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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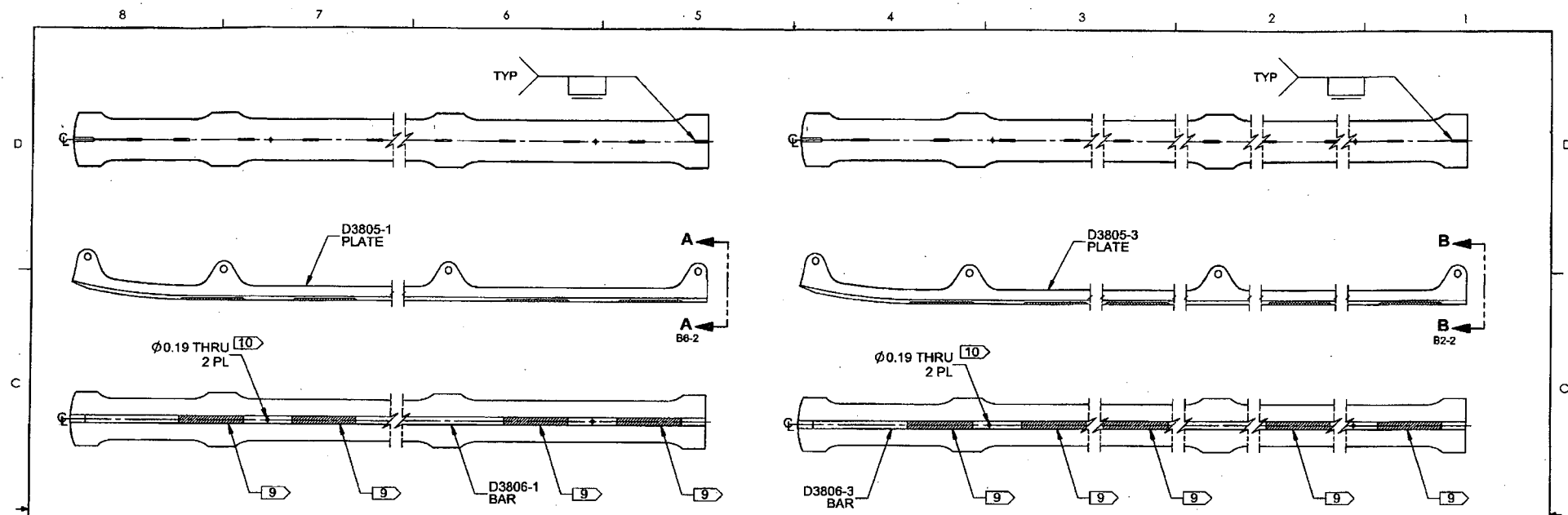
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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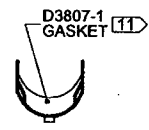
NOTE: Date & initial all entries

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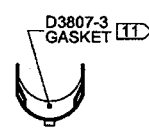


D3805-041 FWD WEARPLATE ASSY, LOW GEAR

D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C5-2



VIEW B-B C1-2

RELEASED
2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

| | | | |
|------------|-----------------|--|--------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. D3805 | REV. B |
| MFG. APPR. | | SHEET 2 OF 8 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
| DATE | 11.09.16 | <small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

Dart Aerospace Ltd

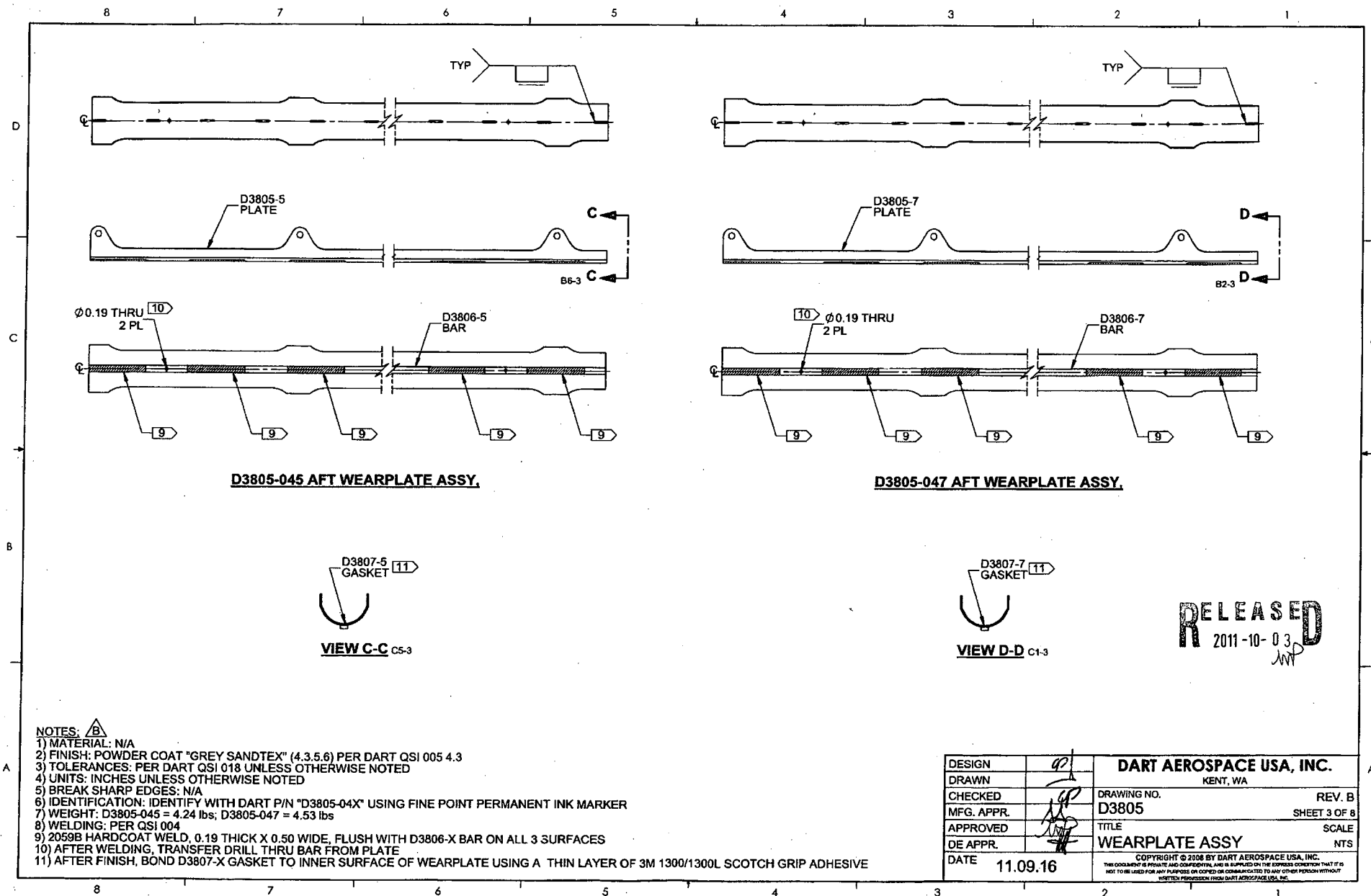
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NOTE: Date & initial all entries

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|------------|----------|--|--------------|
| DESIGN | 92 | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 3 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
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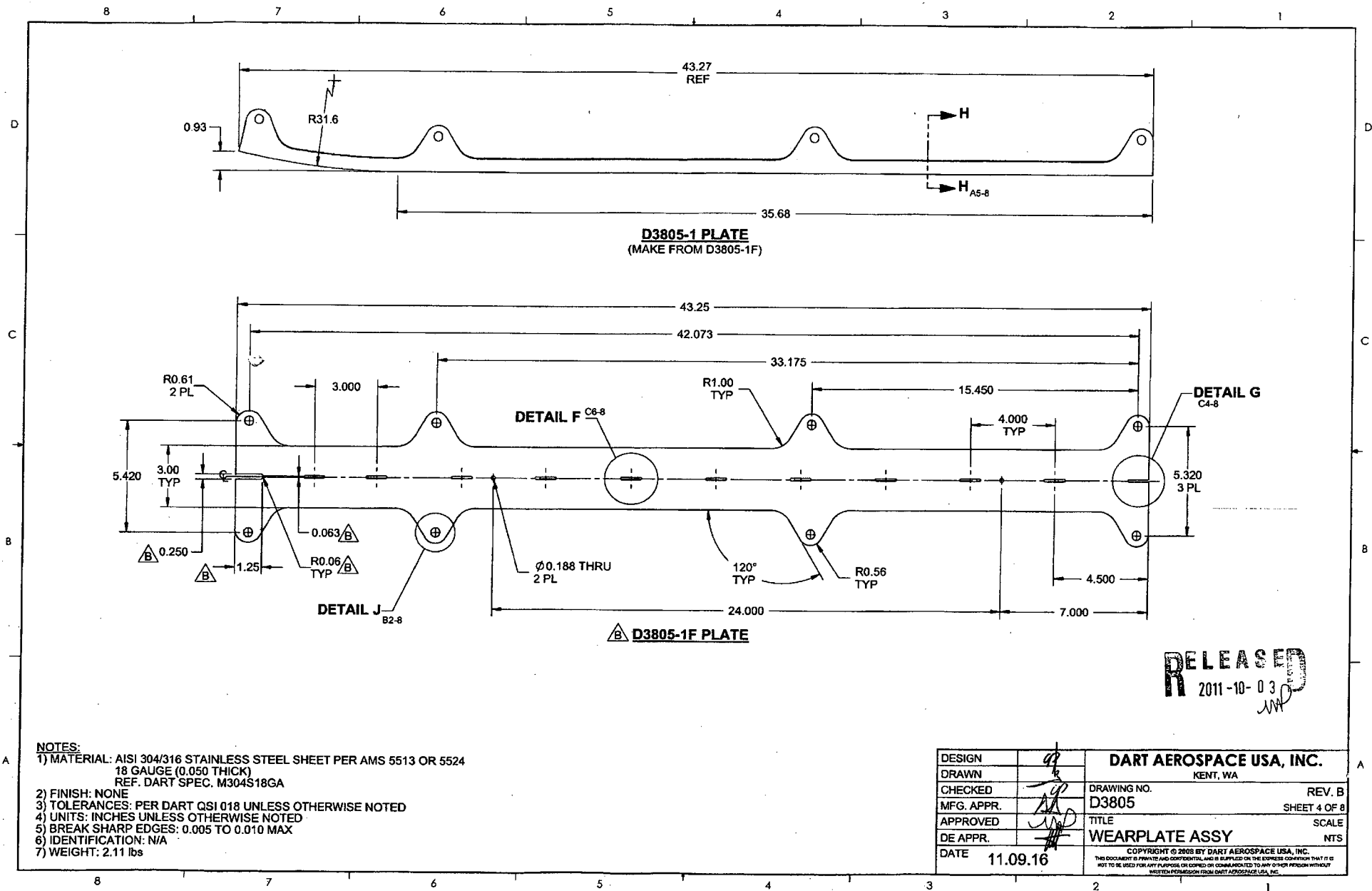
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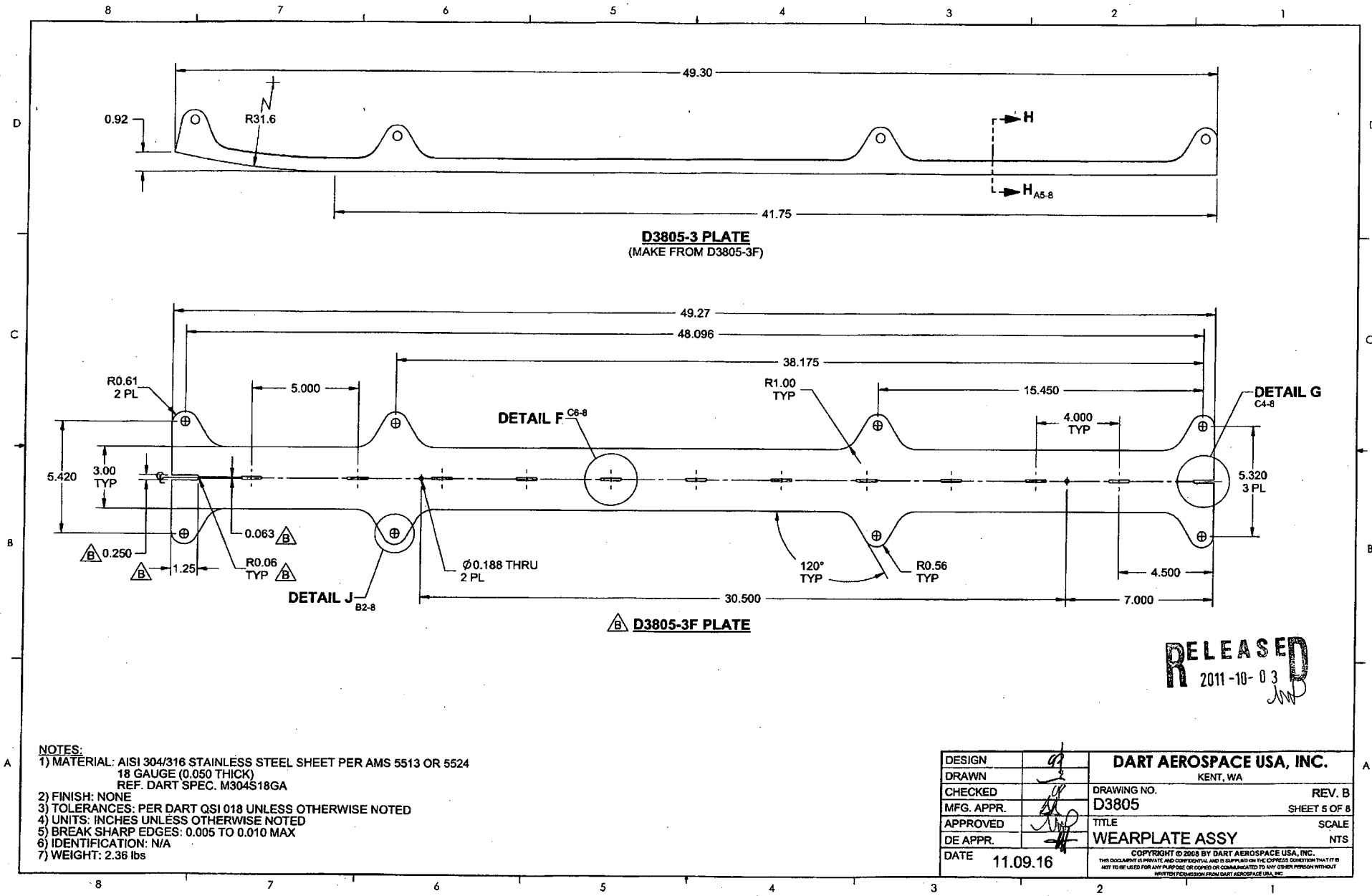
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76787



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.36 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | 47 | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 5 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
| DATE | 11.09.16 | <small>COPYRIGHT © 2003 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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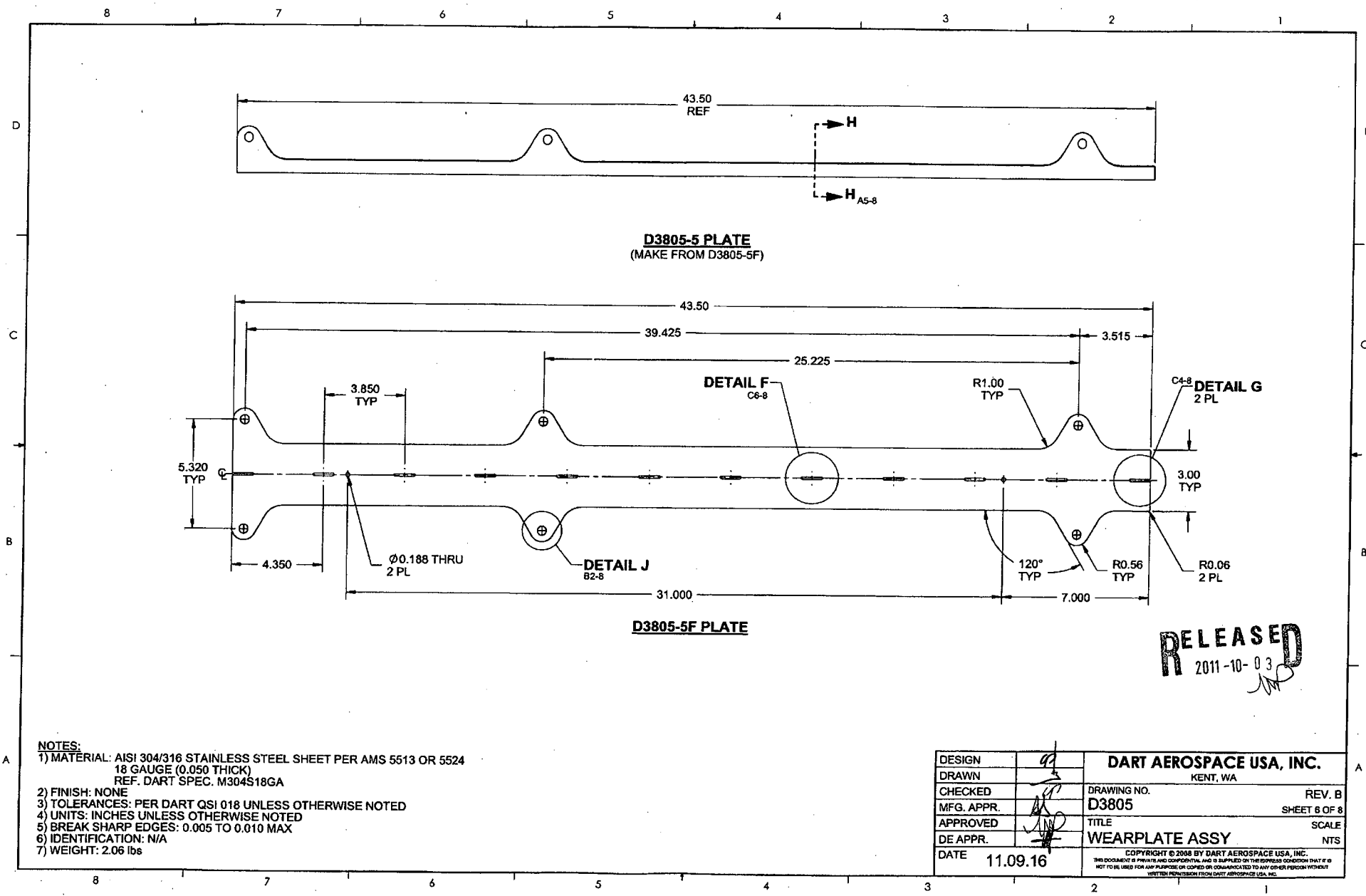
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

76787



D3805-5 PLATE
(MAKE FROM D3805-5F)

D3805-5F PLATE

RELEASED
2011-10-03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.06 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 6 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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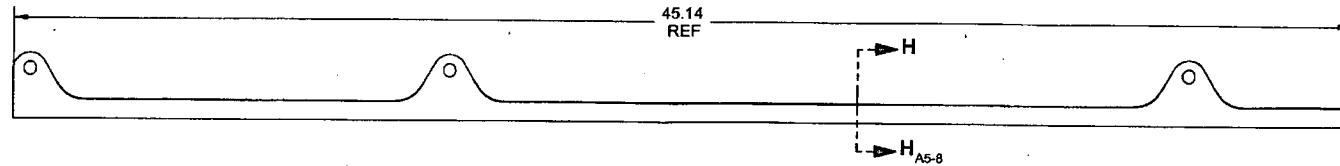
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

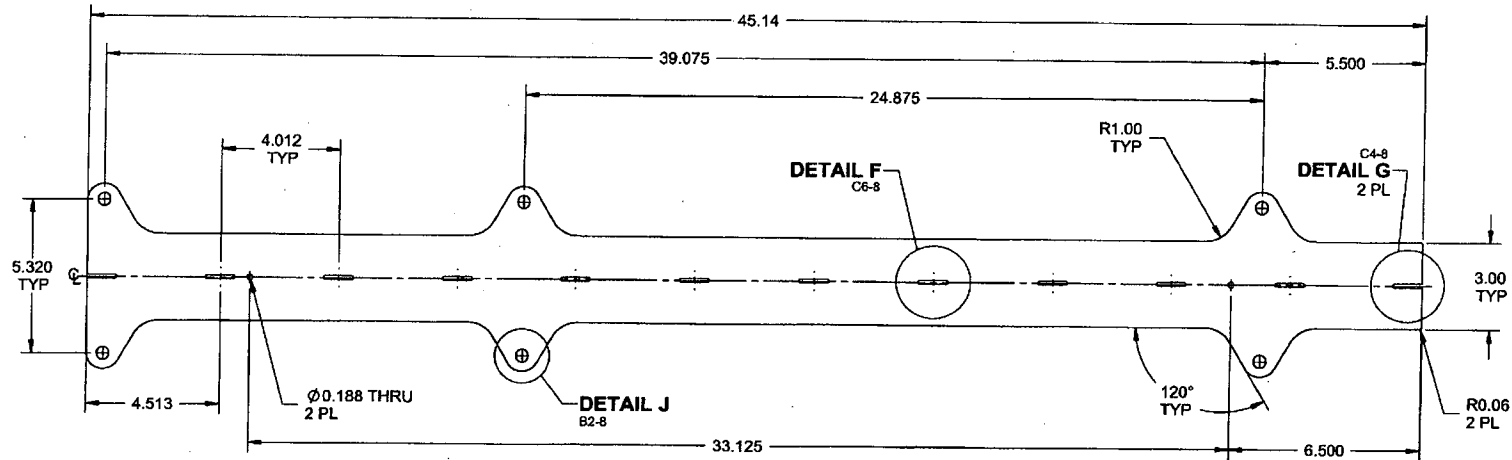
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

76787



D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

| | | | |
|------------|---|---|--------------|
| DESIGN |  | DART AEROSPACE USA, INC. | |
| DRAWN |  | KENT, WA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. |  | D3805 | SHEET 7 OF 8 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | WEARPLATE ASSY | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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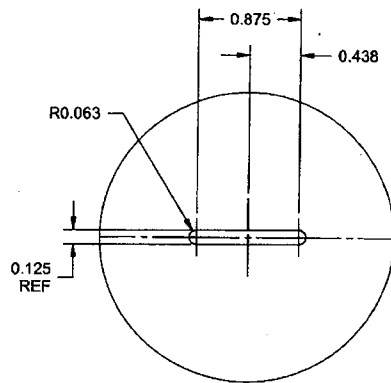
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

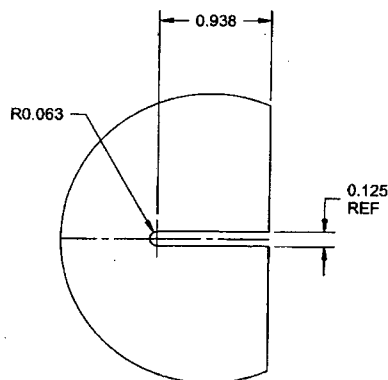
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

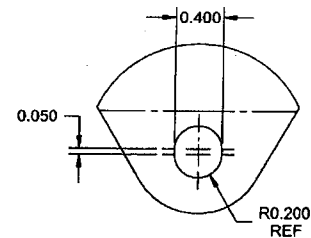
76787



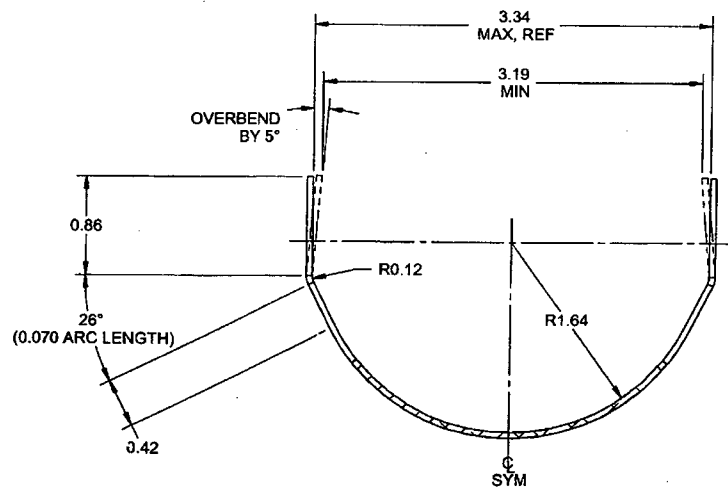
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

RELEASED
2011-10-03

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|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 8 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries